

Date: Friday, 08/02/2008 11:18:29 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Job Number : 37305 Estimate Number : 13142 P.O. Number : This Issue : 08/02/2008 S.O. No. : Prsht Rev. : NC First Issue : / / Type : SMALL /MED FAB Previous Run : 37209 Written By : Checked & Approved By : Comment : Est Rev A 08-01-30 new issue DD verified by:EC	Drawing Name : HINGE HALF Part Number : D37481 Drawing Number : D3748 U/R Project Number : N/A Drawing Revision : U/R Material : Due Date : 08/02/2008 <div style="text-align: right;">Qty: 20 Um: Each</div>
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POSITIVE
RECALL

08-02-11

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S11GA	304/316 .125 Sheet
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**Comment:** Qty.: 0.0358 sf(s)/Unit Total: 0.7161 sf(s)

304/316 stainless steel sheet .125" thick

(M304S11GA)

Batch: *104934**IB 8-2-11*

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3748

Dwg Rev: *U/R*Prog Rev: *U/R**IB 8-2-11*

2- Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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*IB 8-2-11***Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK*08/02/11**(20)*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1- Deburr if necessary

08/02/11 *(20)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 08/03/17

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 08/02/2008 11:18:29 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE HALF

Job Number: 37305

Part Number: D37481

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S/S 08/02/11

20

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3748

S/S 08/02/11

20

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL

08.02.11

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W54

Pl 08.02.11

20

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/11

20

Job Completion



08/02/11

20

POSITIVE RECALL
EFFECTIVE 08.02.08 AUTH [Signature]
RELEASED 08.02.11 DATE [Signature]

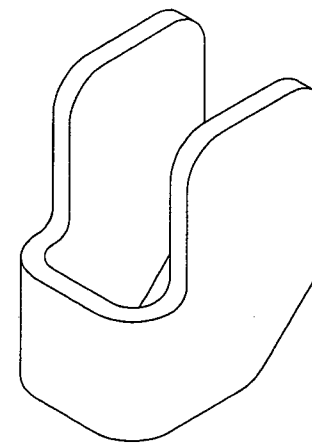
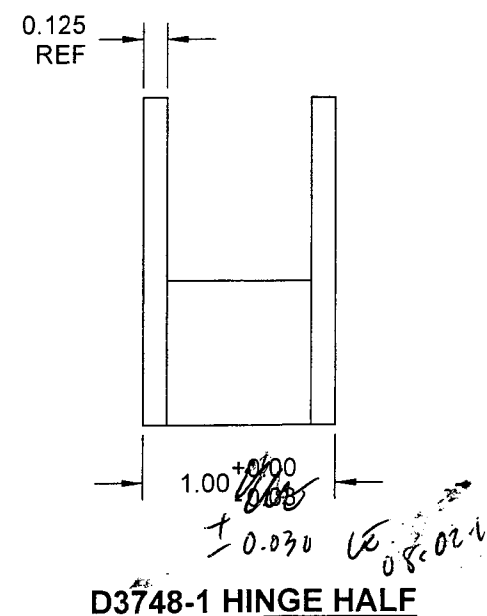
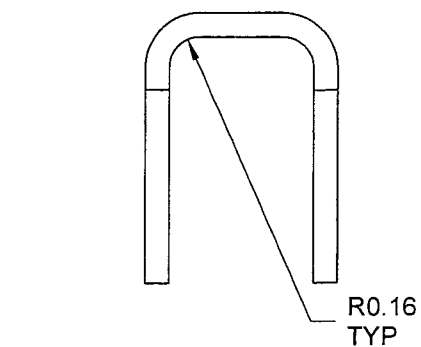
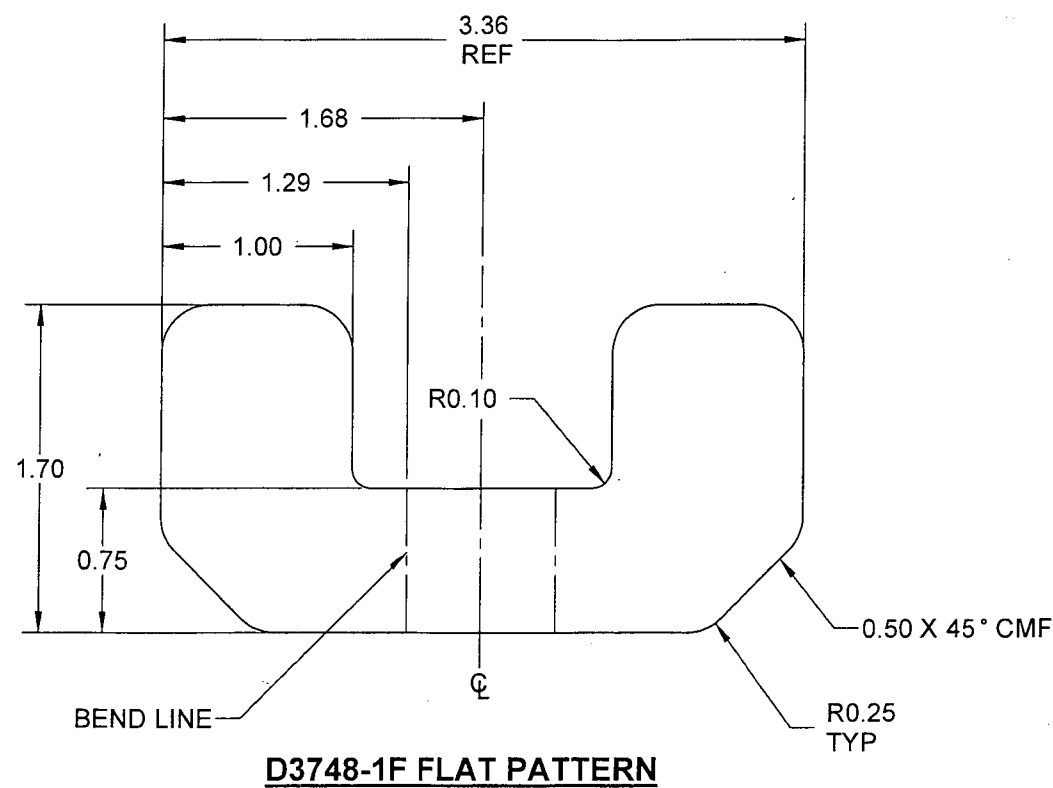
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PRELIMINARY ISSUE
ASS 08.02.08

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.125 THICK
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC M304S11GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.15 lbs

A	INITIAL RELEASE	AJS	08.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3748	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		HINGE HALF	1:1
DATE	08.02.05	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Receiving Report

Date: 07/07/06

Batch No: 17104934

Supplier: Magna

Dart P/O: 4098

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection 570702 N/A ☒
 Work Order 570702 N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
	17303R0750	60	0	0	60	

Initials of receiver (if shipment OK) Level 12 EP

Production/Admin:
 Date 07/07/09
 Received/Costing RCP 5031
 Initial CS

Location

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

Sub-Total
 G.S.T.

1211.70
 72.70



Plant: Praça 1ª de Maio, nº 9 - Centro - Timoteo - MG - 35160-018 - Brazil

ACESITA S.A. ASSOCIADA À ARCELOR

Head Office: Av. João Pinheiro, nº 580 - Centro - Belo Horizonte - MG - 30130-180 - Brazil

PACKING LIST / TEST REPORT

Number: 220364
ACESITA Order: 62846704
Date: 18/11/2006
Invoice: 3099E06

Customer:
ARCELOR STAINLESS USA
350 HUDSON STREET, 4TH FLOOR, 10014
NEW YORK/N.Y.
USA
P.O.NR.: 784188 / 1022

Ship to:
GULF & NORTHERN TRADING CORP
2201 MT EPHRAIM AVENUE

Part Number: 0.012*X48

Steel grade: AISI 304 Finish: 2B Product: COIL
Dimensions: 3,02 mm x 1219 mm - 0,120 in x 48,00 in
Marks:

Chemical composition

Heat nr.	C %	Mn %	Si %	P %	S %	Cr %	Ni %	Mo %	N2 PPM	Ti %	Cu %	Co %				
605897H	0,035	1,11	0,440	0,023	0,002	18,10	8,04	0,051	523	0,0039	0,0600	0,130				
643028D	0,047	1,15	0,390	0,034	0,001	18,11	8,08	0,023	508	0,0038	0,0290	0,119				

Results

Test/Variable	Unit	605897H9001B		643028D8002B		605897H9003B		605897H9002B					
		H	T	H	T	H	T	H	T	H	T	H	T
Tensile Strength	KSI	99,64	103,12	102,69	102,11	99,64	103,12	99,64	103,12				
Yield Strength 0.2%	KSI	48,01	46,27	50,33	50,04	48,01	46,27	48,01	46,27				
Elongation 2"	%	56,00	56,00	52,00	53,00	56,00	56,00	56,00	56,00				
Grain Size		07/07	07/07	08/07	07/08	07/07	07/07	07/07	07/07				
Hardness RB	HRB	84,93	84,93	87,00	87,00	84,93	84,93	84,93	84,93				
Bend Test (180) T.		Y	Y	Y	Y	Y	Y	Y	Y				
Oxalic Test		DUAL	DUAL	STEP	STEP	DUAL	DUAL	DUAL	DUAL				
Net Weight	LB	16.435		13.593		15.057		16.203					
Gross Weight	LB	16.578		13.736		15.200		16.347					

Heat & Lot Identification:

OK

Surface quality / dimensions:

OK

Heat treatment: Minimum Solution anneal temp. 1900 F

Standards:

ASME SA480/SA480M 04

ASTM A240/A240M 06B

ASTM A480/A480M 06A

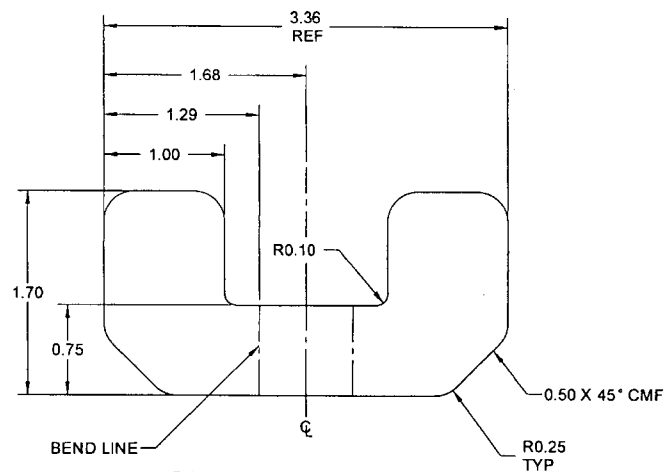
ASME SA240/SA240M 04

Remarks:

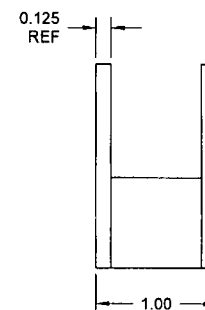
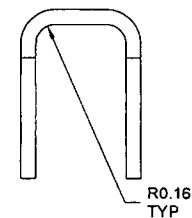
- Free from mercury contamination.
- Certify that the results above are correct and in acc. with the specifications or accepted concession.
- Quality management system certified acc to standard ISO 9001:2000 - Certificate ABS QE Nº 30071.
- Quality management system certified acc to standard ISO/TS 16949:2002 - Certificate ABS QE Nº 38324.
- Environmental management system certified acc to standard ISO 14001:1996 - Certificate ABS QE Nº 65989.

Reginaldo Pinto Barbosa
Qualified Inspector

BY 131



D3748-1F FLAT PATTERN



D3748-1 HINGE HALF

NOTES:

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PER MIL-S-5019 (ANNEALED) 2B FINISH
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CHECKED	IE	DRAWING NO. D3748			REV. A
MFG. APPR.	ND				
APPROVED	IE	TITLE HINGE HALF			SHEET 1 OF 1
DE APPR.	IE				
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RELEASED
16 08.02.25